

Work Order ID 74915

74915

Page 1

Thursday, October 13, 2011 12:39:45 PM

Item ID: D2221 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 350 Basket Base
 Start Date: 10/13/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/19/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: 11-10-13 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2221	Rev H

100 Large Fab 0.00
100
 Large Fab Memo 0.00
 Large Fab

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
 2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221
 3- tack weld mesh on basket as per dwg D2221
 A/R ER316 S.S. Rod Batch: 118366

PLEASE NOTE
 IF MAKING -041A OR -043A :
 DRILL HOLES FOR GAS SPRING
 IN D3825-041 AS PER
 DSI 9473

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
110
 QC Memo 0.00
 Quality Control

12.02.27 1X *[Signature]*

12.02.27 *[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74915

Thursday, October 13, 2011 12:39:45 PM

N900040100

Stop ***NS2***

*** 1 ***

*** 1 ***

Run Start *NR1*

Stop ***NR2***

Hand Finishing

8/2/2027

1Xp m. 12/03/01

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130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
-----	---	------	--	--	--	--	--	--	--

130

Powdercoat

Powder Coating

Memo

1- Plug holes prior to

1ST COAT:

START TIME: 3:00OVEN TEMPERATURE: 400 °FFINISH TIME: 3:30

*****2nd coat if necessary*****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

1X M/L 12/03/01

140

QC3- Inspect Part Finish

0.00

140

QC

Quality Control

Memo

0.00

*1 BL 12.8.2**M120222*

Dart Aerospace Ltd

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12-03-2
1

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Picklist Print

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Page 1

Work Order ID: 74915

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Parent Item: D2221

D2221

Parent Item Name: 350 Basket Base

Start Date: 10/13/2011

Required Date: 10/19/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.09.02 Added D3442-1 KJ/JLM
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N
 10.06.29 added pressure wash DD ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

✓ D2221-1 Rib		Manufactured	No			100	Each	16.0000	1	1			
------------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
WA	16	
71372	4	
72297	12	

✓ D2221-5 Rib		Manufactured	No			100	Each	12.0000	2	2			
------------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
WA	10	
71218	10	
WA006	2	
67117	2	

✓ D2221-7 Rib		Manufactured	No			100	Each	8.0000	1	1			
------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location	Loc Qty	Loc Code
WA	5	
71219	1	
73203	4	
WA006	3	
72731	3	

W/O:		WORK ORDER CHANGES					
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Page 2

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Parent Item: D2221

D2221

Parent Item Name: 350 Basket Base

Start Date: 10/13/2011

Required Date: 10/19/2011

Start Qty: 1.00

Required Qty: 1.00

D2232-3 Manufactured No

100 Each 5.0000 2 2

✓ ***D2232-3***
Basket Hinge

**

Pl 12.02.23

Location

Loc Qty

Loc Code

ST 72929

5 5

B78903 → (2)

D2235-1 Manufactured No

100 Each 11.0000 2 2

✓ ***D2235-1***
Basket Rib

**

Pl 12.02.23

Location

Loc Qty

Loc Code

WA 73202
WA005 66895

7 7 4 4

B78636 → (2)

D2581 Manufactured No

100 Each 35.0000 2 2

✓ ***D2581***
Mounting Bracket

**

Pl 12.02.23

Location

Loc Qty

Loc Code

WA 69739
70766
73079
73762

35 2 2 10 21

B77045 → (2)

D3442-1 Manufactured No

100 Each 19.0000 2 2

✓ ***D3442-1***
Shim

**

Pl 12.02.23

Location

Loc Qty

Loc Code

WA 71224
(71783)

19 4 15

(2)

W/O:		WORK ORDER CHANGES					
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D2221

Parent Item Name: 350 Basket Base

Start Date: 10/13/2011

Required Date: 10/19/2011

Start Qty: 1.00

Required Qty: 1.00

D3825-041 Manufactured No

100 Each 6.0000 2 2

✓ ***D3825-041***

Rib Assembly (Basket End)

**

Pl 12.02.23

Location

Loc Qty

Loc Code

WA006

6

72727

6

B77529 → ②

D3826-041 Manufactured No

100 Each 4.0000 2 2

✓ ***D3826-041***

Rib / Gusset Assembly

**

Pl 12.02.23

Location

Loc Qty

Loc Code

WA

4

72728

4

B77676 → ②

D3827-041 Manufactured No

100 Each 9.0000 1 1

✓ ***D3827-041***

Rib Assembly (Inboard)

**

Pl 12.02.23

Location

Loc Qty

Loc Code

WA

9

72083

3

72729

6

①

D3832-1 Manufactured No

100 Each 2.0000 1 1

✓ ***D3832-1***

Mesh (Base)

**

Pl 12.02.23

Location

Loc Qty

Loc Code

WA

2

72702

2

B78635 → ①

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Parent Item: D2221

D2221

Parent Item Name: 350 Basket Base

Start Date: 10/13/2011

Required Date: 10/19/2011

Start Qty: 1.00

Required Qty: 1.00

D3833-1

Manufactured No

100

Each

12.0000

2

2

D3833-1

Mesh (Base End Face)

**

pc 12.03.23

Location

Loc Qty

Loc Code

WA

12

70470

6

71834

1

72866

5

377521 → 2

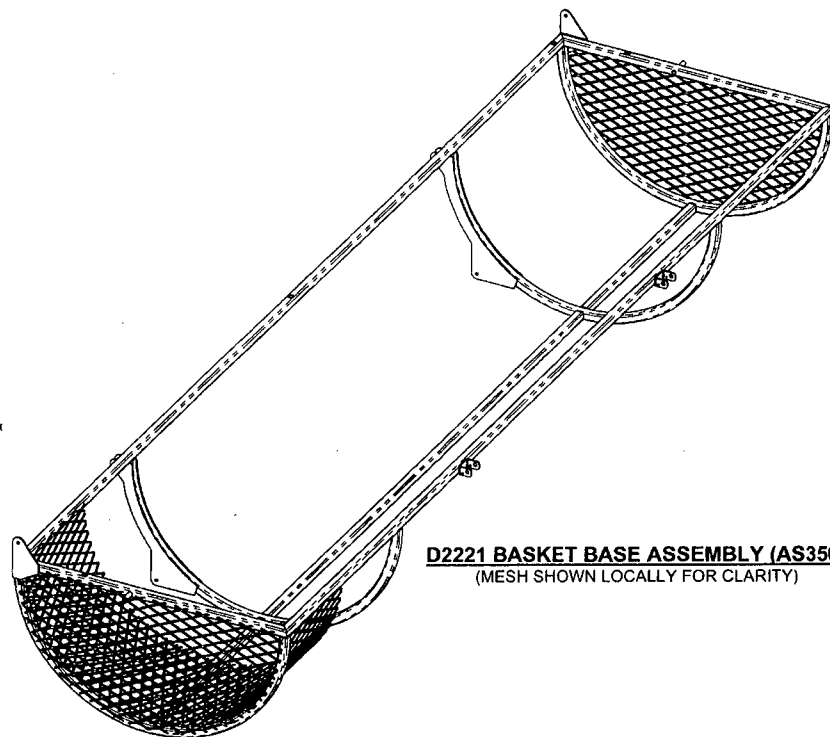
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NOTE: Date & initial all entries



D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74915 M.L.5
11/10/11

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

RELEASED
06/11/11

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN G8-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/5-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL. TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BW		
CHECKED	JSS	DRAWING NO.	REV. H
MFG. APPR.	JSS	D2221	SHEET 1 OF 5
APPROVED	JSS	TITLE	SCALE
DE APPR.	JSS	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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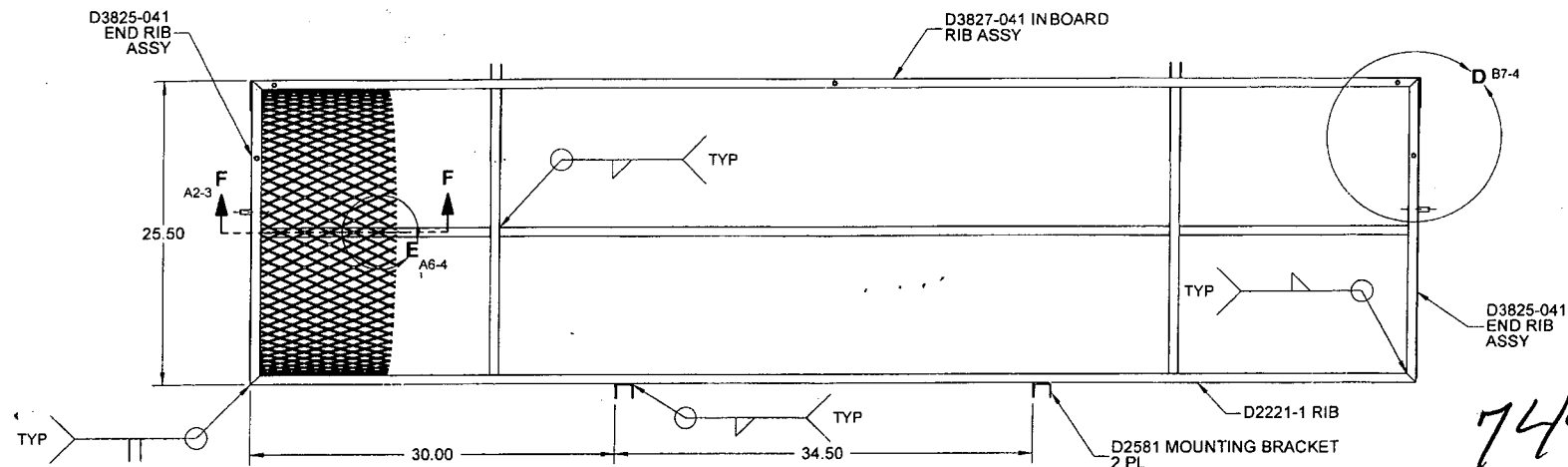
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

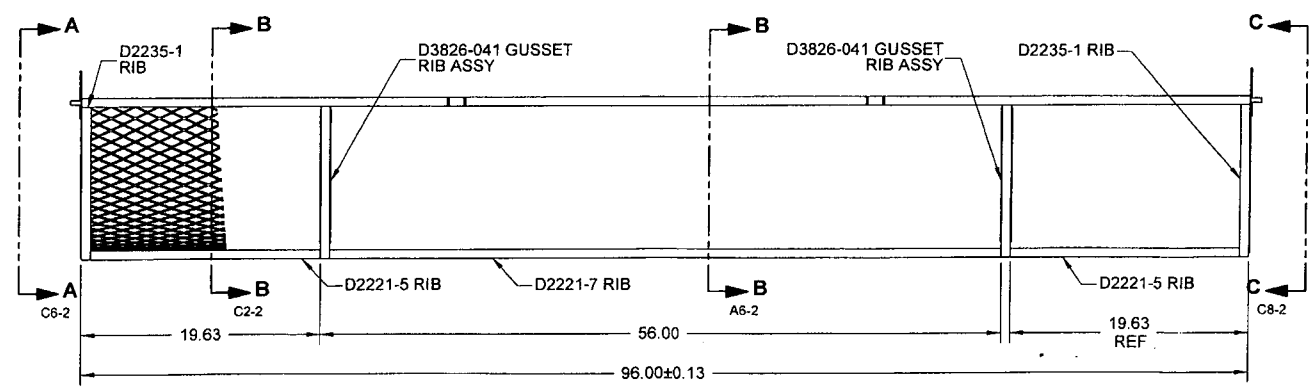
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NOTE: Date & initial all entries

74755





74915



D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
06/11/18 NAD

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 2 OF 5
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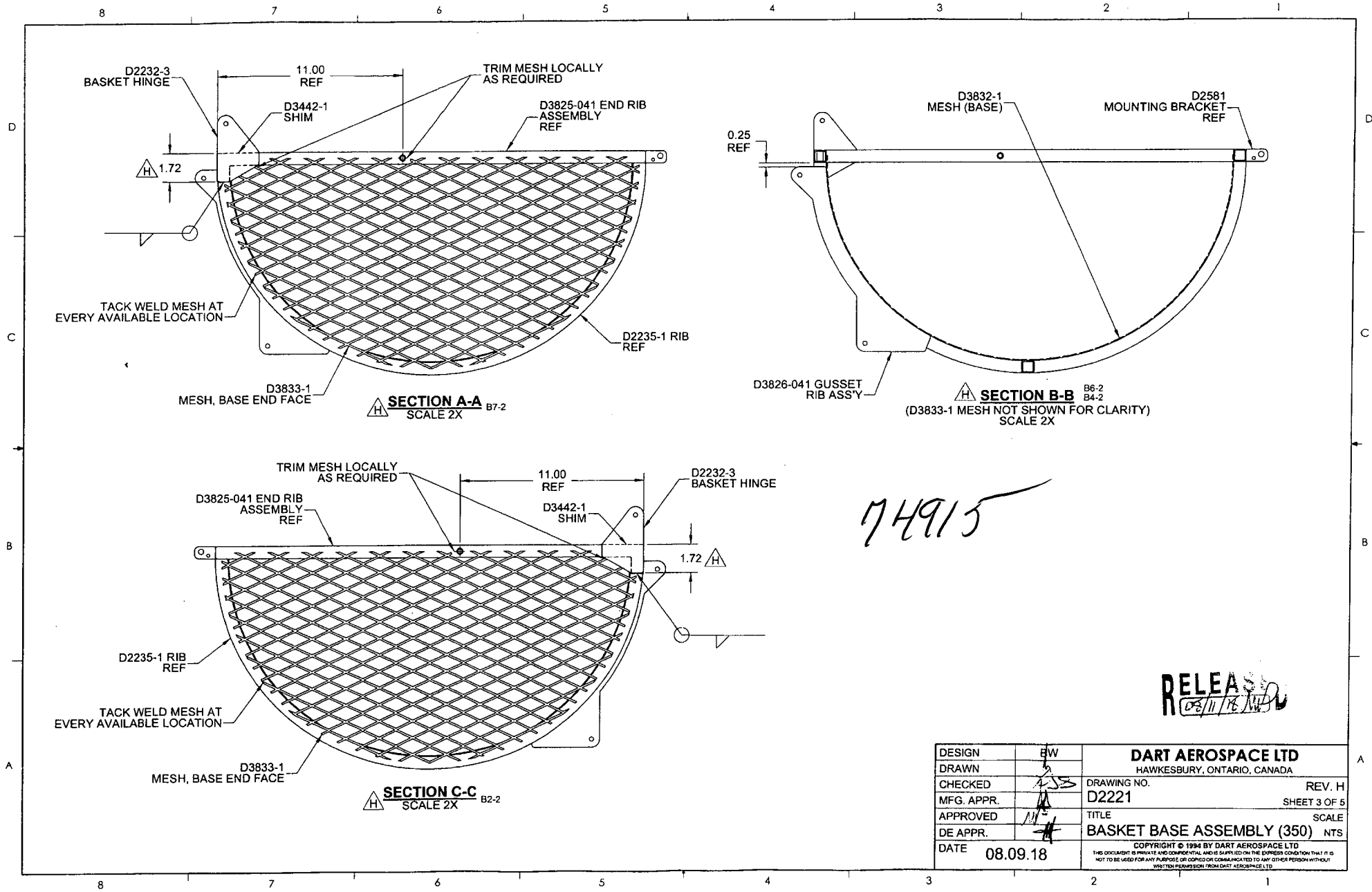
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DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2221	REV. H
MFG. APPR.		SHEET 3 OF 5	
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	
DATE	08.09.18	NTS	

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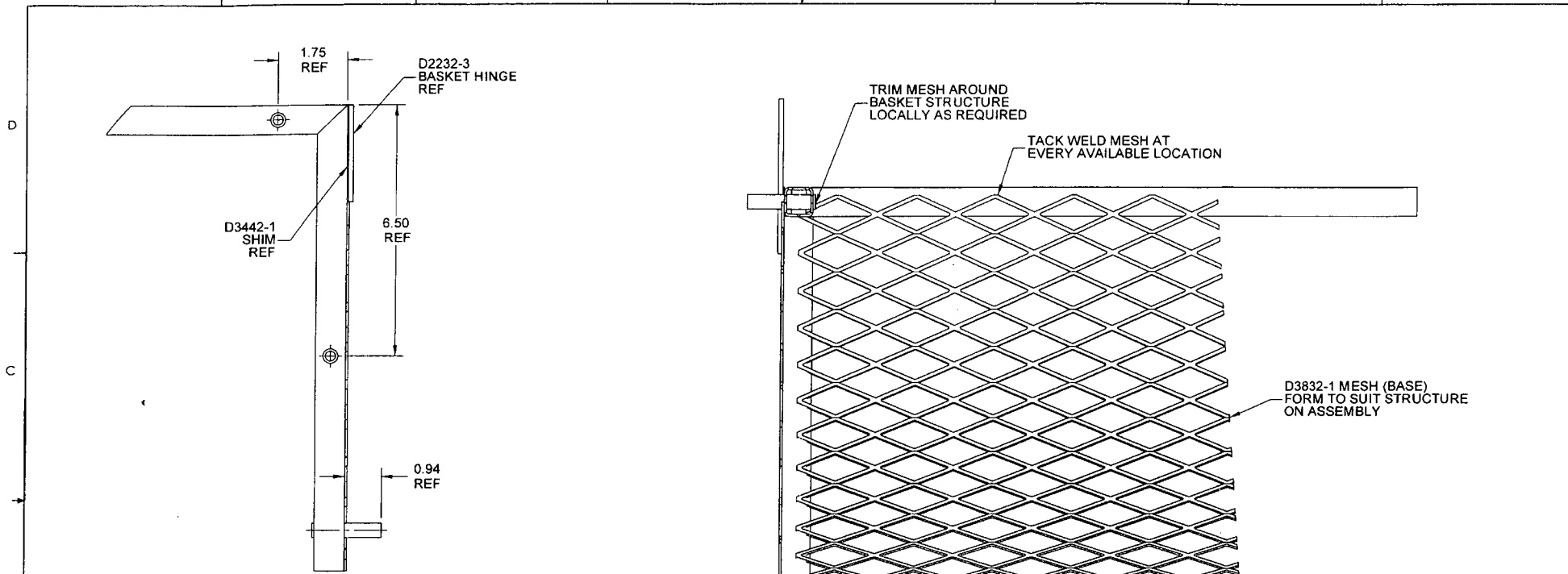
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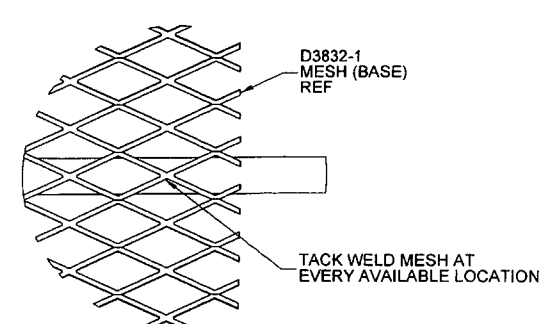
14915

71755

8 7 6 5 4 3 2 1



DETAIL D
SCALE 4X D2-2



DETAIL E
SCALE 4X C6-2

SECTION F-F
SCALE 4X D7-2

RELEASED
08/11/18

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D2221	REV. H
MFG. APPR.	<i>[Signature]</i>	TITLE	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	BASKET BASE ASSEMBLY (350)	
DE APPR.		SCALE NTS	
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1

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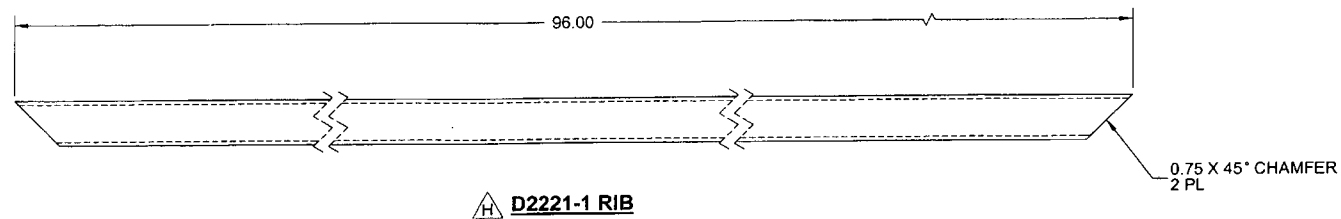
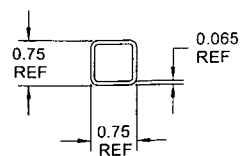
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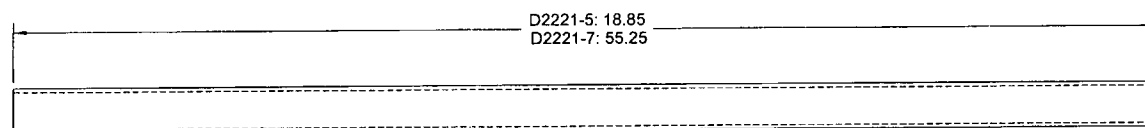
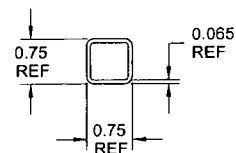
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D2221-1 RIB



D2221-5/-7 RIB

RELEASED
08/11/18

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. H
MFG. APPR.	MD	D2221	SHEET 5 OF 5
APPROVED	SW	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries